

## SPECIAL ELECTRODES FOR COBALT BASED ALLOY FOR SURFACING PLAIN CARBON AND ALLOY STEEL

### Alloy Basis

Co, Cr, W, Ni

### Characteristics :

Wear-facing electrodes with cobalt-based alloy (Stellite) to retain hardness even at high temperatures. Has high resistance to corrosion, oxidation, heat and impact.



### Typical Application

Electrodes Used for in chemical, rubber, oil and sugar industries as well as in steel mills. Surfacing of work-pieces requiring high corrosion, oxidation, heat and impact resistance. Surfacing of valves, conveyor screws, knives, hot-shearing blades, dies, cutting edges, etc.,

### Mechanical Properties

Hardness :

As welded 32 - 42 HRC

### Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	100 - 130	130 - 160	170 - 200

### Availability:

Standard Size: 5.0, 4.0, 3.15 in 350 mm length

Packing: 2 kg.

### Procedure

Clean the weld metal surface by Grinding, SME A28 may be used as a buffer layer. Deposit holding short arc. Minimum two layers to be deposited holding the electrode at 90 Degree to the weld surface.